

Work Order ID 134258-2

134258

Page 1

Item ID: D3197-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 7/07/15

Start Qty: 200

2

Cust Item ID:

Required Date: 7/07/15

Req'd Qty: 200

2

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: JUL 08 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3197

Rev B

100

100

BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

DAS

25

9-89

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.02

HAAS CNC vertical machine #1

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

DAS

25

9-89

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

DAS

25

9-89

Work Order ID 134258

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134258

Page 2

Item ID: D3197-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 7/07/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/07/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

0.00

0.00

6 0 157-27

140

140

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

6 0 JH 205-08-01

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

6x 15/08/04

DAS

36

8-89

Work Order ID 134258

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Page 3

Item ID: D3197-041

Revision ID:

Item Name: Bar

Start Date: 7/07/15

Start Qty: 2.00

Required Date: 7/07/15

Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

3:20 PM

FINISH TIME:

1:30 PM

OVEN TEMPERATURE:

200 PM

0.00

6x p 11/10/10

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

6x 15/08/05

180

Small Fab

0.00

180

Small Fab

Small Fab

Memo

Assemble D3197-041 as per Dwg D3197

0.01

1x 15/08/24

DAS
36
9-89

DAS
36
9-89

Work Order ID 134258

134258

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Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 7/07/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/07/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>①</u>			DAS 38 9-89 AUG 24 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>st 250</u> Memo	0.00 0.00				<u>1</u>			DAS 27 9-89 AUG 25 2015
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>ML5</u>			AUG 27 2015 MF 15-8-29

Picklist Print

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Page 1

Work Order ID: 134258

Parent Item: D3197-041

Parent Item Name: Bar

134258

D3197-041

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2690-5

Manufactured No

180 Each 18.0000

2

4

**

15/08/05 DAS 36 9-89

D2690-5

Lanyard Assembly

Location

Loc Qty

Loc Code

ST012a

18

119601

12

124411

6

3

B135073(9x)

*

D3242-1

Manufactured No

180 Each 22.0000

2

4

**

15/08/24 DAS 36 9-89

D3242-1

Tag

Location

Loc Qty

Loc Code

GA

22

119565

2

129592

20

40

B135074(2x)

D3489-3-200

Manufactured No

180 Each 12.0000

2

4

**

15/08/05 DAS 36 9-89

D3489-3-200

Pip Pin

Location

Loc Qty

Loc Code

GA

12

119335

10

120097

2

102

M7075T73R1.000

Purchased No

180 f 38.0370

2.42

7

**

14.625 SL 15-7-29

M7075T73R1 000

7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT018

38.037

m127647

38.037

Picklist Print

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Work Order ID: 134258

Parent Item: D3197-041

Parent Item Name: Bar

134258

D3197-041

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

180

Each

1,445.000

2

4

**

15/08/05

DAS
36
9-89

MS21042L3

Nut

LocationLoc QtyLoc Code

FP001

393

M130922

393

GA

436

M131317

436

ST305

616

116549

12

126333

49

M128401

2

M128754

2

M132123

17

M132382

534

100

Each

55.0000

2

4

**

15/08/05

DAS
36
9-89

MS27039-1-24

Purchased

No

MS27039-1-24

Screw

LocationLoc QtyLoc Code

GA

15

m127432

15

ST284

40

m127432

40

12

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Shop Packet Print

Picklist Print

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Work Order ID: 134258

134258

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 7/07/15

Required Date: 7/07/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0363J

Purchased

No

180

Each

2,109.000

6

12

15/08/05

DAS
36
9-89***NAS1149D0363.I***

Washer

LocationLoc QtyLoc Code

CA

569

m130799

569

GA

1126

m128429

138

m132677

988

ST269

414

m126319

7

m131618

1

m132317

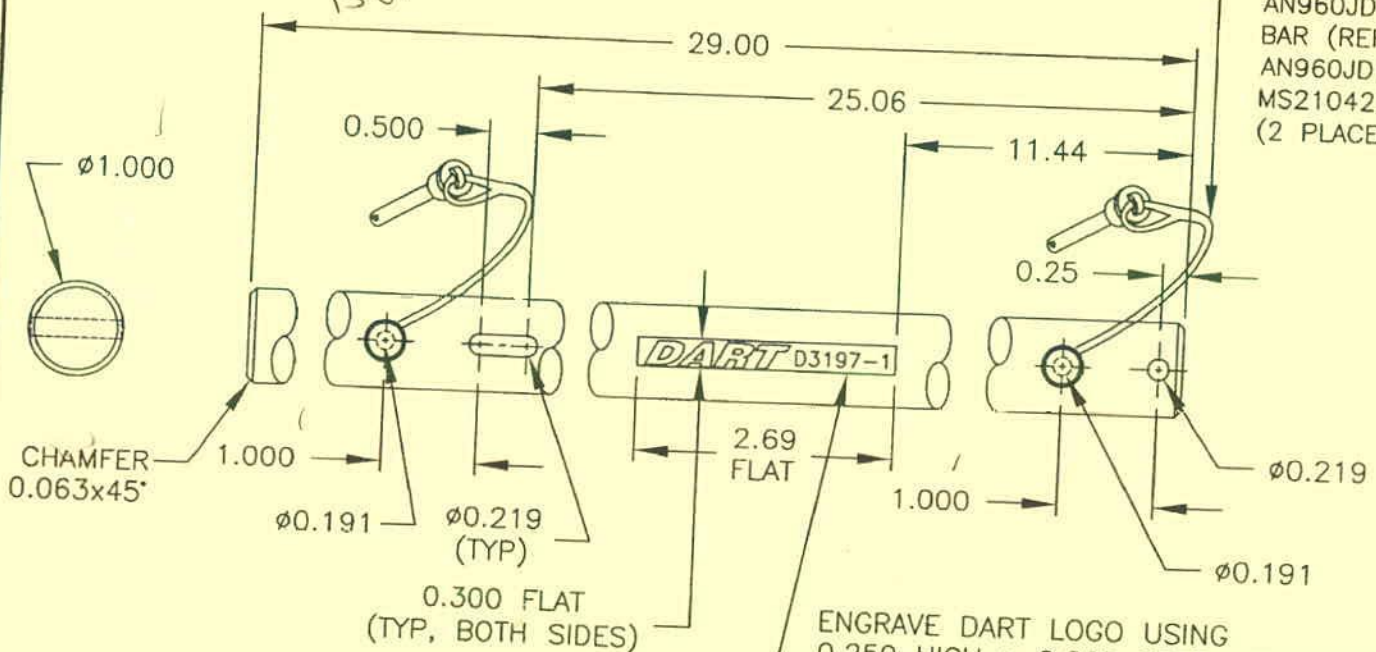
406

36



RELEASED

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

ENGRAVE DART LOGO USING
0.250 HIGH x 0.005 DEEP LETTERING
AND P/N USING 0.150 HIGH x 0.005
DEEP LETTERING ON BOTH SIDES

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) Ø1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	DRAWING NO.	D3197	REV. B
		TITLE	BAR	SHEET 1 OF 1
				SCALE 1:1
	A	03.07.01	NEW ISSUE	
	B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG	